

Work Order ID 52732

October 13, 2009 7:01:47 AM

Page 1

Item ID: D350-604-041

Accept

Revision ID: D/A1

Item Name: Rear Locker Extender

Setup Start

Stop

Start Date: 10/09/09 Start Qty: 1.00

Required Date: 11/06/09 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: CZDate: 09/10/13

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-604-041 CHG002

HJ for BG 09/11/06

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 10561

Description: D350-604-041 Rear locker extender.

Supplier: Delastek.

Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B 112351CZ 09/10/13 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52732

Page 2

October 13, 2009 7:01:47 AM

Item ID: D350-604-041

Accept



Setup Start



Revision ID: D/A1

Stop



Item Name: Rear Locker Extender

Start Date: 10/09/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/06/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Packaging

Memo

0.00

Packaging

Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.

Pg 9/11/05

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Check hole locations to template. DT 8824 Check process sheet and audit.

*=> Sorlulo**(X) 4*

140

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

Pg 9/11/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 52732

October 13, 2009 7:01:47 AM



Page 3

Item ID: D350-604-041

Accept



Setup Start



Revision ID: D/A1

Item Name: Rear Locker Extender

Stop



Start Date: 10/09/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/06/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00		SB 09/11/09		1	0		
160 Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D350-604-041 Location: _____ PPP Rev: _____	0.00 0.00							
170 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

09/11/09

09/11/10
MF 09-11-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 13, 2009 7:01:47 AM

Page 1

Work Order ID: 52732

Parent Item: D350-604-041RevD/A1

Parent Item Name: Rear Locker Extender

Comments:

Start Date: 10/09/09

Required Date: 11/06/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

2600-6

Purchased

No

100

Each

58.0000

4.0000 ✓



Camlock Stud

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

58

110836

2

111993

12

112251

44

D2269RevB1

Manufactured

No

120

Each

1.0000

1.0000



Decal

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

47413

1

D350-604-041P

Purchased

No

140

Each

0.0000

1.0000



Rear Locker Extender

D2268RevB1

Manufactured

No

150

Each

9.0000

1.0000 ✓



Decal

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

9

47289

9

4 10/09/10/13

BS2916 CU

52732

10/11/09 (1)

47289

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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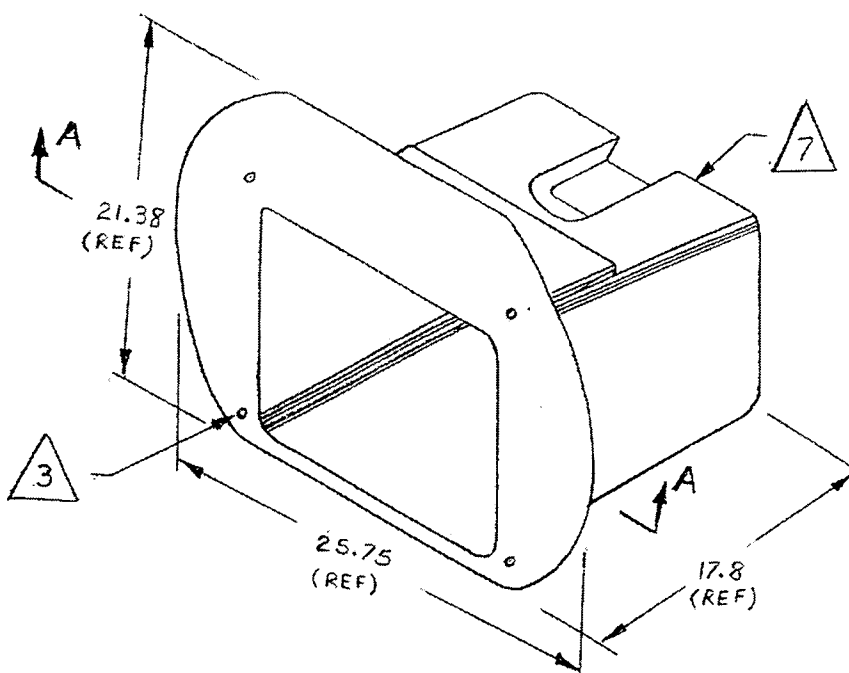
NOTE: Date & initial all entries



DESIGN	JB	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	DRAWING NO. D2273	REV. D SHEET 1 OF 1
DATE	02.04.01	TITLE	350 REAR LOCKER EXTENDER	SCALE NTS
B	96.05.27	RE-DRAWN		
C	02.01.30	CLARIFY MATERIAL, LAYUP, AND TOOLING		
D	02.04.01	REMOVE EPOCAST, ADD SURFACE FINISH		

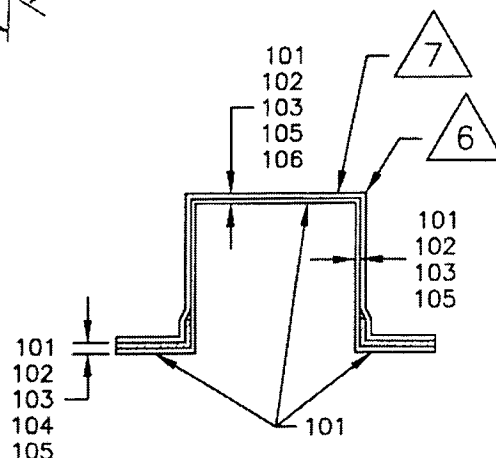
RELEASED
02 04 03 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32732



NOTES:

- 1) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING.
- 2) LAYUP USING DT8010 MOLD. WET LAYUP NO BAG/VACUUM.
- 3) TRIM & DRILL PER DT8020. OPEN HOLES TO $\phi 0.257$ (4 PLACES).
- 4) MATERIALS:
RESIN: DERAKANE 470-36/411/510A40
FIBRE: 9oz = 9.7 oz 7781 WEAVE "S" GLASS
18oz = 18.0 oz ROVING "E" GLASS.
- 5) CONSTRUCTION:
101-WHITE GLOSS GELCOAT # GEL 944W005.
102-9oz ALL OVER.
103-18oz ALL OVER.
104-18oz RE-INFORCE FRONT FLANGE EXTENDING 2" ON SIDES.
105-9oz ALL OVER.
106-PEEL PLY.
- 6) MATTE TO HOLD DOWN CORNERS AS REQUIRED.
- 7) FINISH THIS SURFACE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S.
- 8) ALL DIMENSIONS ARE IN INCHES.



SECTION A-A

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DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	MIKE M	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
BW	[Signature]	D350-604	SHEET 1 OF 4
DATE	TITLE		SCALE
96:05:27	REAR LOCKER EXTENDER ASSEMBLY		
B	BW	96.05.27	RE-DRAWN

PARTS LIST - D350-604

Qty -041	Part Number	Description
X	D350-604-041	REAR CARGO COMPARTMENT EXTENDER ASS'Y
1	D2273	REAR CARGO COMPARTMENT EXTENDER
1	D2268	PLACARD
1	D2269	PLACARD
4	2600-4	CAMLOCK STUD
4	2600-LW	RETAINING WASHER

REFERENCE ONLY

INSTALLATION INSTRUCTIONS:

1. Remove existing panel from AFT bulkhead of rear cargo compartment at Longitudinal Station 199.3 in.
2. Install cargo compartment extension D350-604-041 picking up with (4) existing camlock receptacles in bulkhead as shown on Sheet 3 and 4.
3. Install decal (D2268) "TOTAL WEIGHT IN THIS COMPARTMENT..." on forward face of cargo compartment extender as shown on sheet 4.
4. Install decal (D2269) "WHEN COMPARTMENT EXTENSION IS USED..." on inside face of cargo compartment door, underneath existing placards, as shown on sheet 3.

52732

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-604 REV. B

REF TCCA STC: SH90-4

REF FAA STC: SR00463NY

PURPOSE:

The 2600-4 Camloc Studs may be too short for some installations.

CHANGE:

The qty (4) 2600-4 Camloc Studs are replaced with longer 2600-6 Camloc Studs. It is acceptable to install either 2600-4 or 2600-6 Camloc Studs. The parts list of D350-604 Rev. B is amended as follows:

QTY	PART NUMBER	DESCRIPTION
-041		
X	D350-604-041	REAR CARGO COMPARTMENT EXTENDER ASSY

IS:

4	2600-6	CAMLOC STUD
---	--------	-------------

WAS:

4	2600-4	CAMLOC STUD
---	--------	-------------

REFERENCE ONLY

52732

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01
APPROVED <i>[Signature]</i>
BY: D. SHEPHERD (DE # 02)
DATE: 09.07.01
CERT. NO.: SH90-4
ISSUE NO.: 3

A	NEW ISSUE, NCR 09-046	CP	09.07.01
REV.	DESCRIPTION	BY	DATE
DESIGN	92	DART AEROSPACE LTD	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED	2	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9470	SHEET 1 OF 1
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	CAMLOC CHANGE	NTS
DATE	09.07.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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DELASTEK COMPOSITES INC.
2699, 5^{ème} Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	13230
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
04/11/2009	13/10/2009	6044	Chantal Lavoie		PO10561		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0003	Line 3 Rear Locker Extender D350-604-041P B52731 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D Job: 21376			
1	0	1	DKC134-0003	Line 4 Rear Locker Extender D350-604-041P B52732 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D Job: 21377			
1	0	1	DKC134-0003	Line 5 Rear Locker Extender D350-604-041P B52733 U de M : Each Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D Job: 21584			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Quality department


AQ-357



☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Mardi, 2009-09-01 08:48:45
 Utilisateur: marc dubé

Feuille de Procédé

Client :	DART US DART AEROSPACE LTD	Nom Dessin :	REAR LOCKER EXTENDER
Numéro Job :	21377	Numéro Article :	DKC134-0003
Numéro Soumission :	3482	Numéro Dessin :	D350-604-041 & D2273
Numéro B.A. :		Projet Numéro :	DK-362
Cette fois :	2009-09-01	Révision dessin :	A & D
Prsht Rev. :	NC	Matériel :	Derakane 470-36/411/510
Prem. fois :	- -	Date Dûe :	2009-09-08
Job précédente :	21376	Qté:	1 Udm: UNITE
Écrit par :			
Vérifié & Approuvé par :			
Commentaires :	N° de pièce Laminée Dart Aerospace: D2273 N° de pièce Assemblage Dart Aerospace: D350-604-041		

Process Sheet Rév.: 00 Création du premier à partir de la révision
 12 du planning De Delastek Composites

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	AC0085	FREKOTE 3,78L 44-NC
-----	--------	---------------------

Commentair Qty.: 0.02 UNITE(s)/Unit **Total :** 0.02 UNITE(s)

2.0	PRÉPARATION	Préparation du moule
-----	-------------	----------------------



Commentair Setup: 0.00Hrs/ Run: 15.0000Min **Total Run :** 0.2500Hrs

~~Nettoyer le moule à l'aide d'un chiffon humide et sécher à l'air. Selon I.F. # DKC134-0003-5.~~

Note: Afin que le frekote agisse pleinement, le moule doit être libre de toute contamination, enlever tout contaminants à l'aide de Frekote PMC, PMC Plus ou tout autre solvant efficace. Il est permit d'utiliser un abrasif (Doux) afin d'enlever tout accumulation de résine sur le moule.

Appliquer 2 couches de Frekote 44-NC à l'aide du chiffon propre en laissant sécher pendant 15 minutes entre les couches. Le séchage de la dernière couche doit être de 3 heures à température de la pièce avant d'appliquer le Gel Coat.

Date: _____ Sceau: _____

N/A

3.0	AMB0350	Gel Coat Blanc N° Gel 944W005
-----	---------	-------------------------------

Commentair Qty.: 1.580 UNITE(s)/Unit **Total :** 1.580 UNITE(s)

Gel Coat Blanc N° Gel 944W005

N° de Lot: 1-25019-1

4.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

Commentair Qty.: 0.0070 GALLON(s)/Unit **Total :** 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-22176-1

Date: Mardi, 2009-09-01 08:48:45

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 21377

Numéro Article: DKC134-0003

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

5.0	AC0747	Acetone
-----	--------	---------

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)

6.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire la préparation du matériel selon I.F. # DKC134-0003-5 :

Dans une quantité de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% D'acétone.

Date: 14-9-09 Sceau:



7.0	GEL COAT	Application du Gel Coat
-----	----------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Selon I.F. 134-0003

À l'aide d'un fusil à gel coat appliquer une couche entre 15 et 20 millièmes de Gel Coat sur le moule N° DKG 362-010 et laisser sécher pendant un minimum de 2 heures avant de faire le lay-up, mais ne pas dépasser 24 heures de séchage selon l'instruction de travail N° Tec-70.

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Autocontrôle de fabrication. (Visuel du Gel Coat)

Date: 14-9-09 Sceau:



8.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
-----	---------	---

Commentair Qty.: 1.680 LITRE(s)/Unit Total : 1.680 LITRE(s)

Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-25087-1

9.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)

Catalyst N° DDM-9 N° de Lot: 1-22176-1

10.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
------	---------	---

Commentair Qty.: 4.6 VERGE(s)/Unit Total : 4.6 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-7080-1

Date: Mardi, 2009-09-01 08:48:45
Utilisateur: marc dubé

Feuille de Procédé

Cliant: DART US DART AEROSPACE LTD
Numéro Job: 21377

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



Séq.: Machine ou Opération: Description :

11.0 AMB0213 WR1850 Roving 18oz. x 50"

Commentair Qty.: 1.140 KILOGRAMME(s)/Unit Total : 1.140 KILOGRAMME(s)
WR1850 Roving 18oz. x 50" N° de Lot: 1-22202-1

12.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler le matériel selon les dimensions requises à l'aide de gabarit de trimage prévus à cet effet.

Autocontrôle de fabrication. (Selon gabarits)

Date: 4/09/09 Sceau:



13.0 LAMINAGE Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 3.5000Hrs Total Run : 3.5000Hrs

Selon I.F. 134-0003

S'assurer de ne pas trapper d'air entre les rangs

Inscrire les informations suivantes:

Humidité: 35 % Température: 71 °F Heure: 1:40

Date: 14-9-09 Sceau:



14.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.150 LITRE(s)/Unit Total : 0.150 LITRE(s)
Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-25087-1

15.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-22176-1

16.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Injecter les bulles d'air selon I.F.# DKC134-0003-5.

Date: 15-9-09 Sceau:



Date: Mardi, 2009-09-01 08:48:45
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 21377

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

17.0	DÉMOULAGE	Démoulage de la pièce
------	-----------	-----------------------



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Selon I.F.# DKC134-0003-5.

Faire le démoulage de la pièce en poussant de l'air à l'intérieur tout en faisant bien attention de ne pas l'endommager .

Autocontrôle de fabrication.(Visuel)

Date: 15-9-09 Sceau:



18.0	TRIMAGE	Trimage / Rivetage
------	---------	--------------------



Commentair Setup: 0.00Hrs/ Run: 40.0000Min Total Run : 0.6667Hrs

Selon I.F.134-0002

Autocontrôle de fabrication.(Visuel et dimensionel selon le dessin)

Date: 16-9-09 Sceau:



19.0	AAC1021	Dupont Primer N° 7704S
------	---------	------------------------

Commentair Qty.: 0.3400 UNITE(s)/Unit Total : 0.3400 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 2-25136-3

20.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase
------	---------	---

Commentair Qty.: 0.0670 UNITE(s)/Unit Total : 0.0670 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 2-24023-3

21.0	PRIMER	Application primer
------	--------	--------------------



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Appliquer le primer selon I.G. 0008

Date: 21/10/09 Sceau:



22.0	AAC1607	Camlock Stud 2600-4 (or Monadnock 1126000-4)
------	---------	--

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)
Camlock Stud 2600-4 (or Monadnock 1126000-4) N° de Lot: 1-7163-1

Date: Mardi, 2009-09-01 08:48:45

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 21377

Numéro Article: DKC134-0003

Numéro Job:



Séq.:

Machine ou Opération:

Description :

23.0

AAC0682

Washer 2600-LW (1127700)

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)

Washer 2600-LW (1127700)

N° de Lot: 1-6687-1

24.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Selon I.F. 134-0004

Démasquer la pièce.

Assembler les quatre (4) Camlock Stud N° 2600-4 à l'aide des Lock Washer N° 2600-LW. Selon l'instruction de travail N° I.G.#Pose de stud.

Autocontrôle de l'assemblage (Visuel)

Date: 22-09-09 Sceau:



25.0

IDENTIFICATION

Identification à encre indélébile



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Selon I.F. 134-0005

Faire l'identification de la pièce: N° de pièce D350-604-041

N° de Work Order: #21377

L'identification doit être vers l'extérieur.

OCT 22 2009

Date: 22-10-09 Sceau:



26.0

INSPEC FINAL

Inspection finale



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Date: 22-10-09 Sceau:



27.0

EMBALLAGE

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'emballage de la pièce dans le contenant approprié.

Date: Mardi, 2009-09-01 08:48:46
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 21377

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Date: 26-10-09 Sceau:

